

Work Order ID 126897

Monday, December 01, 2014 8:13:10 AM

126897

Page 1

Item ID: D350-689-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Dual High Back Seat Assembly
Start Date: 12/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/1/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 12-12-14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3022	B
D3023	A
IIN D350-689	B

100 Document Control 0.00

100

DC

Memo 0.00

Doc.Control -USB or Paperwork

Photocopy bluefiles and create labels as per PPP D350-689-041 CHG002

N/A MLS 12-01-09

105 Large Fab 0.00

105

Large Fab

Memo 0.00

Large Fab

1-Bend D3023-1 form edge of back pan as per dwg D3023 using D3017-041 back frame
2- Bend D3022-1 as per dwg

1 EL 12-12-23

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126897

Page 2

N900040100

Setup Start *NS1*

Item Name: Dual High Back Seat Assembly

Stop *NS2*

Start Date: 12/1/2014 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 12/1/2014 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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Item ID: D350-689-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/1/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115

Chemical Conversion Coat per QSI005 4.1

0.00

115

HandFinish

Memo

0.00

Hand Finishing

Chemical Conversion Coat only D3023-1 and D3022-1

1FFDEC 23 2014

117

QC7-Inspect Chemical Conversion Coat

0.00

117

QC

Memo

0.00

Quality Control

D14-12-24

118

0.00

118

Small Fab

Memo

0.00

Small Fab

Assemble back panel to back frame as per dwg

IX14/12/24
DAS
96
989

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Item ID: D350-689-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dual High Back Seat Assembly
 Start Date: 12/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/1/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
119	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
119									
QC	Memo	0.00							
Quality Control									
120	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	Powder coat								
	START TIME: 1:35								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 2:05								
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									

① 14-12-24

1 φ 15-1-6

DAS 34 9-89

IX

15/01/06

DAS 36 9-89

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Item ID: D350-689-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Dual High Back Seat Assembly

Stop *NS2*

Start Date: 12/1/2014 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 12/1/2014 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

Large Fab

0.00

Small Fab

Memo

Small Fab

Assemble frames and seat and back pan as per IIN-D350-689 page 15

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89

JAN 07 2015

160

Identify as per dwg & Stock Location:_____

0.00

160

Packaging

Memo

0.00

Packaging

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Item ID: D350-689-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/1/2014 Req'd Qty: 1.00 ***1***

Customer:

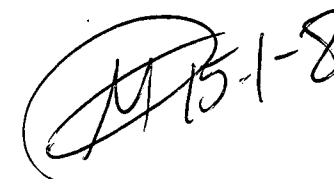
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ 1501-09



Picklist Print

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Page 1

Work Order ID: 126897

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H Removed Sub-Parts 06-02-09 JLM
 IPP Rev:I As per NCR 070 06-09-06 JLM
 per DSI 9498 DD 10.02.12 verified by:JLM
 IPP Rev:J as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20600-AD4W2		Purchased	No				Each	1,283.000		40			
MS20600-AD4W2									**				
Rivet													

Location	Loc Qty	Loc Code
CCK004	776	
m126475	776	
ST309	407	
125578	7	
m125708	400	
WA003	100	
m126475	100	

14/12/24
 DAS
 36
 9-89

MS20600-AD4W3 Purchased No

MS20600-AD4W3

Cherry Rivets

Location	Loc Qty	Loc Code
CCK004	600	
m129795	600	
ST309	520	
m130018	520	
WA003	67	
m127476	7	
m129278	60	

14/12/24
 DAS
 36
 9-89

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Work Order ID: 126897

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

D3022-1

Manufactured No

100

Each

6.0000

1

1

D3022-1

Seat Pan

EL 1/4-12-23

Location

Loc Qty

Loc Code

WA001

6

125400

1

125401

2

125841

1

126273

1

126274

1

D3023-1

Manufactured No

100

Each

2.0000

1

1

D3023-1

Back Panel

EL 1/4-12-23

Location

Loc Qty

Loc Code

WA001

2

124125

1

125742

1

D3016-041

Manufactured No

114

Each

0.0000

1

1

D3016-041

Seat Frame Assembly

127190x1

EL 1/4-12-23

D3017-041

Manufactured No

114

Each

0.0000

1

1

D3017-041

Seat Back

127192x1

EL 1/4-12-23

Picklist Print

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Work Order ID: 126897

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

AN3-12A

Purchased

No

140

Each

186.0000

3

3

AN3-12A

Bolt

**

DAS
36
9-89

15/01/06

Location

Loc Qty

Loc Code

CA

5

m129682

5

GA

20

m128398

20

ST349

161

m130566

161

3

D3021-041

Manufactured

No

140

Each

0.0000

1

1

D3021-041

Tube Assembly

**

DAS
36
9-89

12/12-23

D3024-1

Manufactured

No

140

Each

11.0000

3

3

D3024-1

Spacer

**

DAS
36
9-89

15/01/06

Location

Loc Qty

Loc Code

ST015

11

111838

11

D3028-1

Manufactured

No

140

Each

34.0000

4

4

D3028-1

Stud

**

DAS
36
-89

3127195 (3x)
15/01/06

Location

Loc Qty

Loc Code

ST015

34

109929

14

124022

20

4

Picklist Print

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Work Order ID: 126897

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

D3029-1 Manufactured No

140 Each

30.0000

2 2

D3029-1

Spring

**

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

30

122745

30

D3030-1 Manufactured No

140 Each

10.0000

2 2

D3030-1

Lock

**

DAS
36
9-89

Location

Loc Qty

Loc Code

ST015

10

111519

5

116996

5

D3031-1 Manufactured No

140 Each

23.0000

2 2

D3031-1

Loop

**

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

23

110906

2

124064

20

79747

1

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1 268.97

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

1,390.000

17

17

MS210421 3

Required Qty: 1.00
15/01/02
DAS 88
363 6
9.89

Nut

Location

Loc Qty

Loc Code

FP001

500

M130922

500

ST305

890

123900

61

M127410

11

M127831

41

M128401

34

M128754

70

M130799

673

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Picklist Print

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Work Order ID: 126897

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

140

Each

4,203.000

6

6

MS21042L 4

Locknut

DAS
36
9-89

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST260a

2000

m130799

2000

ST273A

709

m129934

709

ST305

1482

111827

2

126275

5

m126015

12

m126275

32

m127255

63

m127376

9

m127813

741

m128300

69

m129472

49

m130922

500

MS24693-S272

Purchased

No

140

Each

197.0000

4

4

MS24693-S272

SCREW

DAS
36
9-89

Location

Loc Qty

Loc Code

CA

48

M129682

48

ST292

149

M126119

15

M126190

134

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Shop Packet Print

Page 6

Picklist Print

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Work Order ID: 126897

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

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D350-689-041

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-17

Purchased

No

140

Each

329.0000

4

4

**

DAS
36
9-89

MS27039-1-17

Screw (601.1954)

Location

Loc Qty

Loc Code

GA

46

120142

46

ST273A

150

m127831

150

ST285

133

124326

1

m127305

132

MS27039-1-19

Purchased

No

140

Each

616.0000

6

6

**

DAS
36
9-89

MS27039-1-19

Screw

Location

Loc Qty

Loc Code

ST273A

556

m127904

556

ST284

60

125654

60

MS27039-4-21

Purchased

No

140

Each

54.0000

6

6

**

DAS
36
9-89

MS27039-4-21

Screw

Location

Loc Qty

Loc Code

ST284

54

m127904

4

m129909

50

Picklist Print

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Work Order ID: 126897

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Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 12/1/2014

Required Date: 12/1/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

140

Each

2,001.000

17

17

NAS1149D0332.J

Washer

15/01/06
DAS
36
9-89

Location

Loc Qty

Loc Code

CA	33	
m129682	33	
ST260a	1755	
m130325	1755	
ST269	213	
m128606	14	
m128612	174	
m129624	25	

17

NAS1149D0432J

Purchased

No

140

Each

30.0000

6

6

NAS1149D0432.J

WASHER

15/01/06
DAS
36
9-89

Location

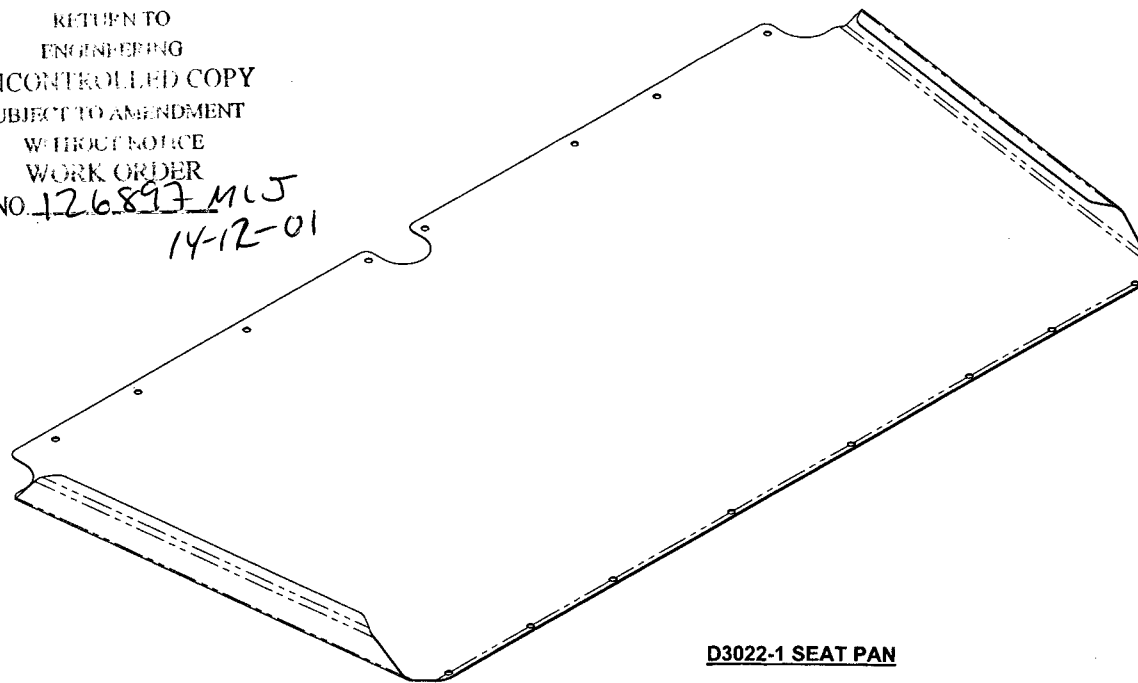
Loc Qty

Loc Code

ST269	30	
124580	7	
125578	23	

M131026
(6x)

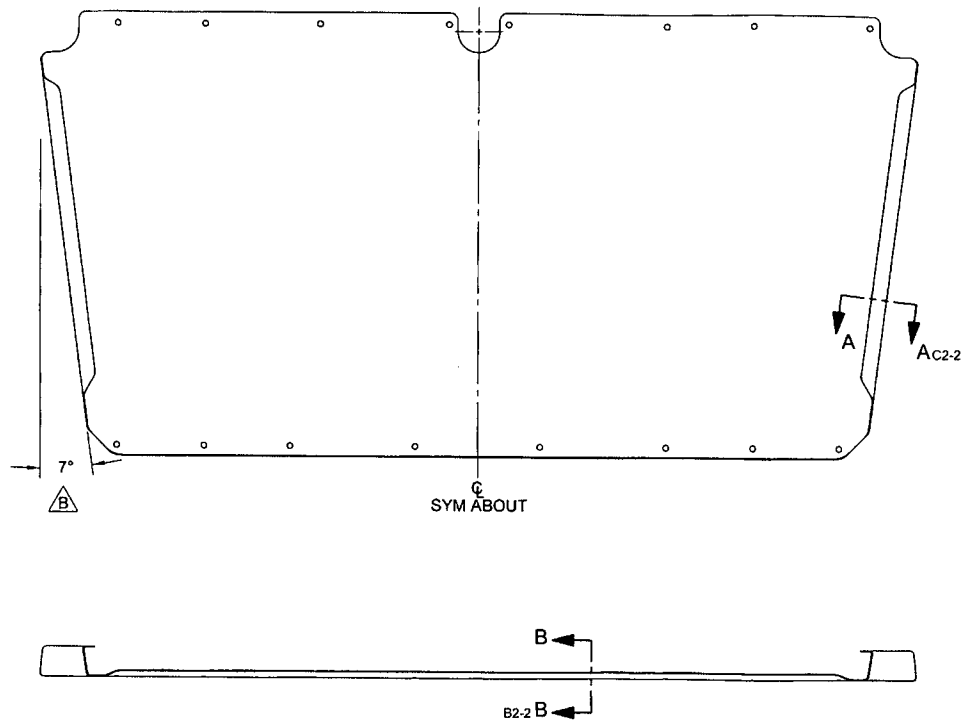
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 126897 MLJ
14-12-01



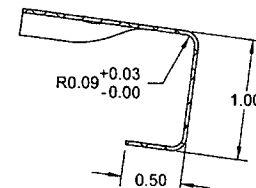
D3022-1 SEAT PAN

RELEASED
 08/12/15 MLJ

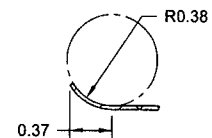
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. BF-2 7" DIM ADDED, DT-3 12.075 WAS 12.325, D6-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.	AJS	08.11.27
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3022 TITLE SEAT PAN REV. B SHEET 1 OF 3 SCALE NTS	
DRAWN	AJS		
CHECKED	[Signature]		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]		
DATE	08.11.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3022-1 SEAT PAN



SECTION A-A C4-2
SCALE 4X



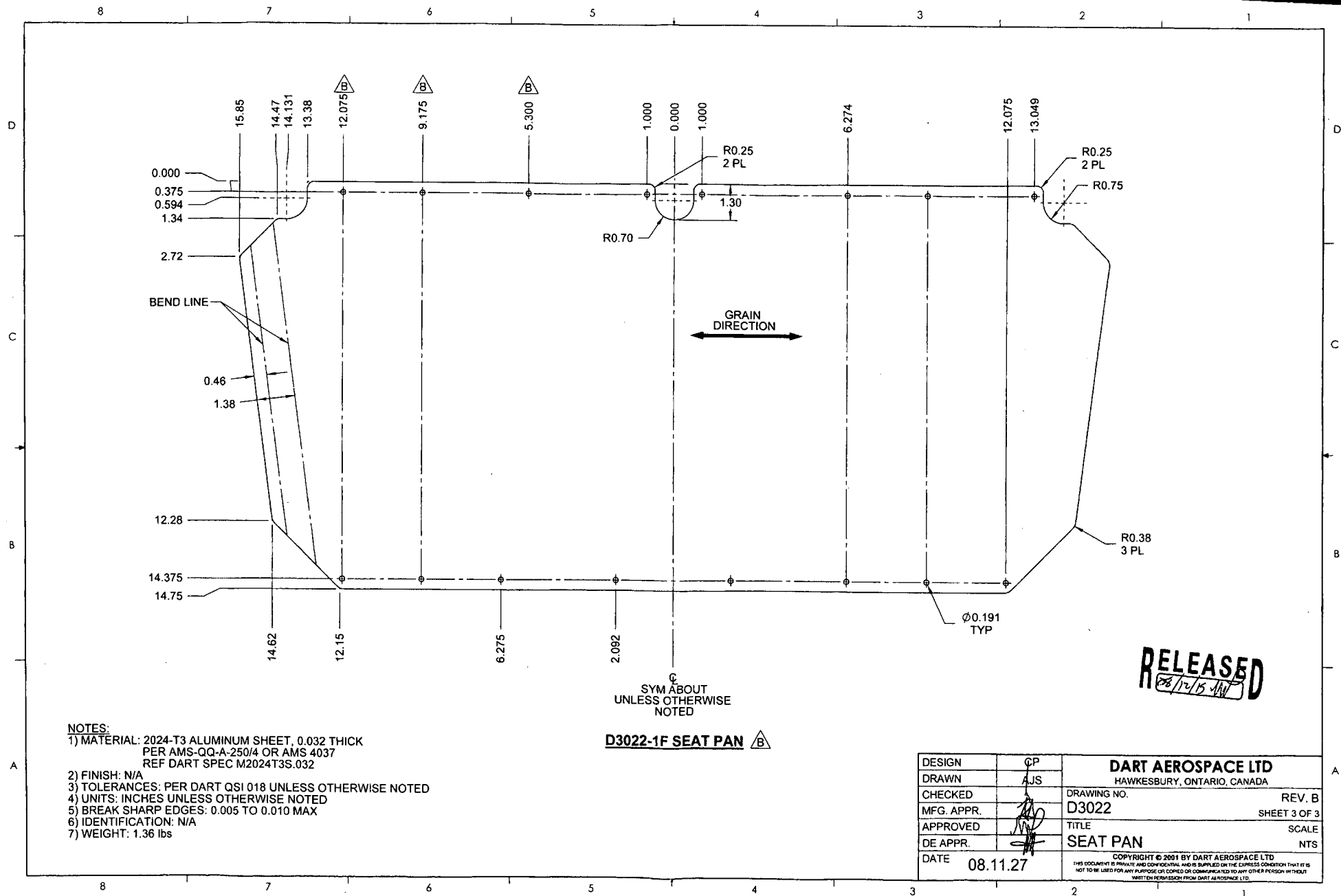
SECTION B-B A6-2
SCALE 4X

RELEASED
08/12/15

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

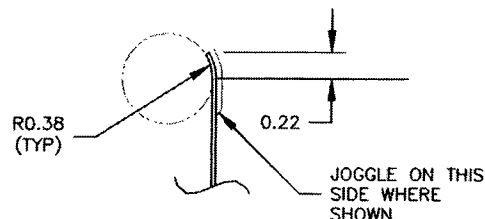
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.		TITLE SEAT PAN	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.11.27		



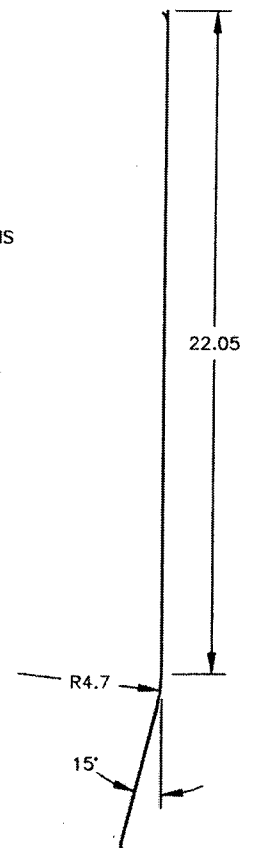
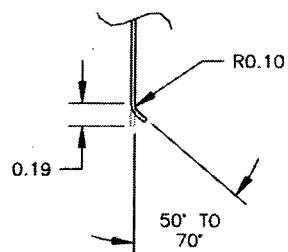
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

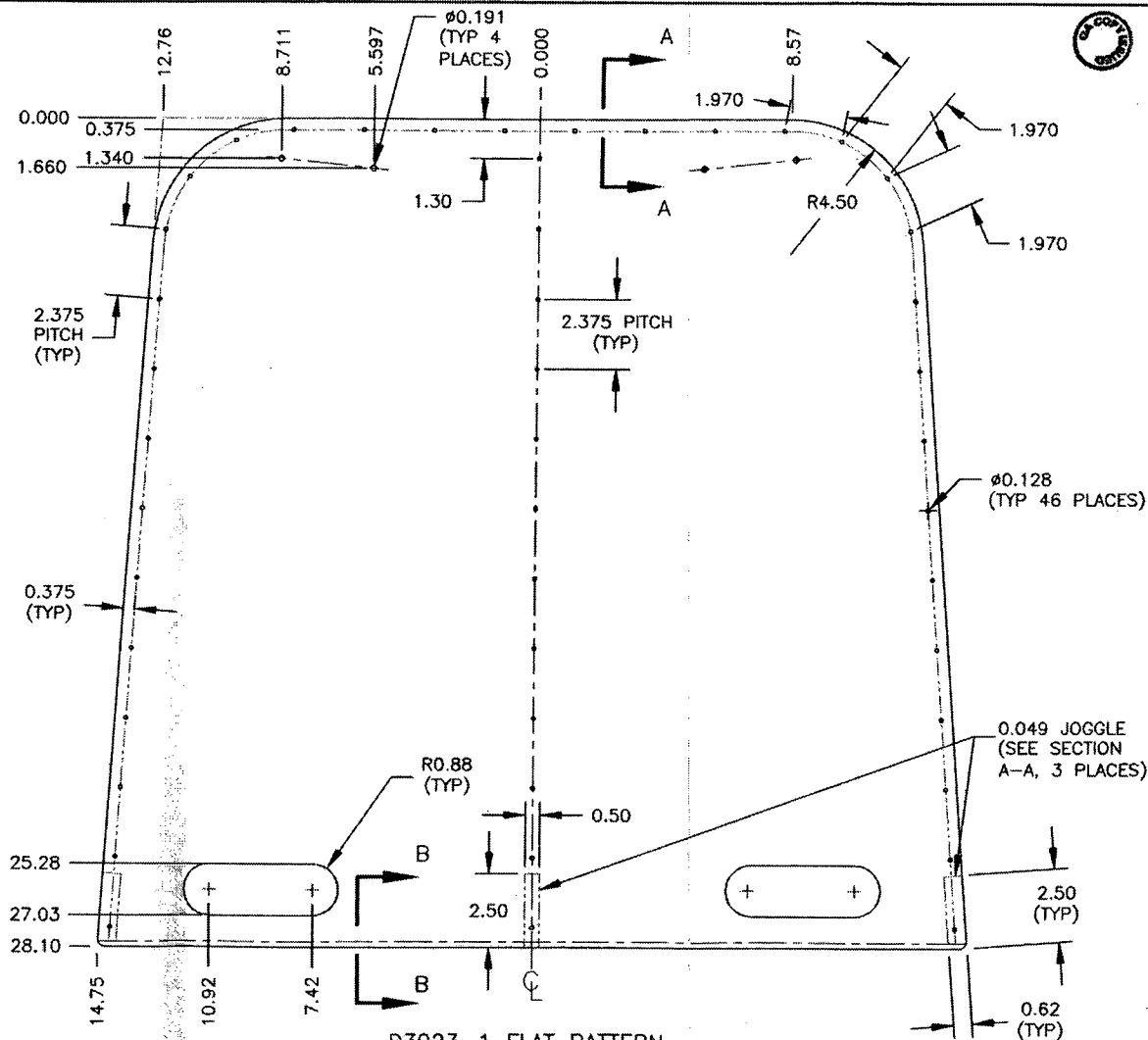
SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4

RELEASED
9.06.07